

Work Order ID 84926

May-29-12 2:51:49 PM

\*84926\*

Page 1

Item ID: D209-669-043

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Replacement Skidtube

Stop

\*NS2\*

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/29 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2906	Rev B								

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002

003 per ECR 12549

110

0.00

\*110\*

Skidtubes

Memo

0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

- Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

- Open holes to 0.500" as per Dwg D2906 without cutting fluid

- Deburr and blow out all chips from

- Acid etch and Alodine tube per QSI 005 4.1

SAD 1206-20

26 12621

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 84926**

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Item ID: D209-669-043

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**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop

**\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC	QC3- Inspect Part Finish Memo	0.00							① 849 12-6-26
Quality Control		0.00							

130

**\*130\***

Skidtubes

Skidtubes

0.00

1 Ø CF 12626

Skidtubes

Memo

0.00

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *M121409*Sikaflex expire date: *13-4-12*Start Time: *16:45* Date: *12-6-26*Fin Time: *17:00* Date: *12-07-04*

pick:

Qty P/N description

1 D2926-3 Web

B/C

*86263*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*NS2\*

Start Date: 29/05/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
*140*	BENDING MACHINE - CROSSTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906								
150		0.00							
*150*	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	-Deburr ends and remove marks from bending								
	- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expantion and finish with 1/2 x 18G to achieve dwg dimention.								
160	QC5- Inspect part completeness to step on W/O	0.00							
*160*	Memo	0.00							
QC									
Quality Control									

→ 12-6-27

→ CF 12-6-27

CF 12-1-4  
BB 12/01/04

1 0 8E12/01/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
						Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  *170* Skidtubes	Large Fab	0.00							
	Memo	0.00							
	-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr								
	-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr								
	-Drill pilot holes for Tow ring using DT8091-3, open to .640" and Deburr								

12-7-14

190

\*190\*  
QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/26/05

4

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

Pressure Wash per QSI005 4.3

0.00

\*200\*

HandFinish

Memo

1 ✓ 12-7-5.

Hand Finishing

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*210\*

Powdercoat

Powder Coating

Memo

11:15 00  
START TIME: 320°F  
OVEN TEMPERATURE: FINISH TIME: 11:45

✓ 12/07/05

220

QC3- Inspect Part Finish

0.00

\*220\*

QC

Quality Control

Memo

✓ 12/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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\*N900040100\*

Setup

Start

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Revision ID:

Item Name: Replacement Skidtube

Stop

\*NS2\*

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

5/26/12

\*240\*

QC

Quality Control

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

250

Packaging

0.00

\*250\*

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-043

Location:

PPP Rev: 1349918

5/26/12 23

260

QC21- Final Inspection - Work Order Release

0.00

\*260\*

QC

Quality Control

Memo

0.00

5/26/12 23

5/26/12 23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Picklist Print

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Page 1

Work Order ID: 84926

\*84926\*  
\*D209-669-043\*

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: new IPP 08.02.13 LL, verified by: DD  
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4202-1		Manufactured	No				Each	81.0000		19			
<b>*D4202-1*</b>													
Spacer													

B84763

Location	Loc Qty	Loc Code
----------	---------	----------

LG	5	
77727	5	
LG002	76	
78806	6	
79810	70	

D2500-1-190		Manufactured	No		110	Each	91.0000		1	1			
<b>*D2500-1-190*</b>													
Ext'n - 'I' Beam Tube 4"													

Location	Loc Qty	Loc Code
----------	---------	----------

HALL	91	
74777	14	
80061	77	

D2926-3		Manufactured	No		110	Each	0.0000		1				
<b>*D2926-3*</b>													
Web													

74777  
80061

Location	Loc Qty	Loc Code
----------	---------	----------

	91	
	14	
	77	

D2855		Manufactured	No		230	Each	21.0000		2	2			
<b>*D2855*</b>													
Cap													

Location	Loc Qty	Loc Code
----------	---------	----------

	21	
	2	
	16	


Location	Loc Qty	Loc Code
----------	---------	----------

FP002	21	
65519	2	
73347	16	

75074	3	
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19 CF 12-1-4

SAJ 12-06-20

① 1 CF 12-6-26

② 2 12-07-06

X2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 84926

**\*84926\***  
**\*D209-669-043\***

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

230

Each

1,090.000

4

4

\*\*

**\*AN3-5A\*** ✓  
Bolt

11112106

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	1090	
115371	46	
117423	124	
118626	31	
119355	200	
120187	500	
121185	189	

AN960JD10L

NAS1149D0332J Purchased

No

230

Each

0.0000

4

4

\*\*

11112101 ✓  
(x4) 11112101

**\*AN960.JD10L\*** ✓

Washer

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

\*\*

111121269 ✓  
(x4)

**\*ALS7-1032-130\*** ✓

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	51	
117717	27	
118966	22	
119775	2	
ST282	2085	
119530	73	
120181	12	
121444	2000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 84926

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

**\*84926\***  
**\*D209-669-043\***

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A	Purchased	No	230	Each	1,458.000	44	44	**	<u>MU 12/07/06</u>
--------	-----------	----	-----	------	-----------	----	----	----	--------------------

**\*AN3C4A\***  
 BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	1458	
120187	57	
120521	28	
120769	38	
<u>121205</u>	1000	
121556	335	X14

AN960C10L	<u>NAS1149C0332</u>	Purchased	No	230	Each	0.0000	44	44	<u>MU 12/06/3</u>
-----------	---------------------	-----------	----	-----	------	--------	----	----	-------------------

**\*AN960C10L \*** ✓  
 washer

D2594-3	Manufactured	No	230	Each	2,418.000	14	14	**	<u>(X44) MU 11/07/06</u>
---------	--------------	----	-----	------	-----------	----	----	----	--------------------------

**\*D2594-3\***  
 O-Ring, 205 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	2418	
65518	41	
79496	984	
79573	50	
<u>79755</u>	1343	X14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

\*\*

\*D2594-1\*

Plug, 205 Skidtube

SL 12107106

Location	Loc Qty	Loc Code
FP001	98	
73401	30	
74442	18	
79495	50	
FP-A	213	
73401	0	
78590	213	

D3564-9

Manufactured No

230

Each

22.0000

1

1

\*\*

\*D3564-9\*

Wearshoe

SL 12107106

Location	Loc Qty	Loc Code
FG	4	
76950	4	
FP001	18	
67590	4	
69943	1	
82255	13	

D3564-11

Manufactured No

230

Each

8.0000

1

1

\*\*

\*D3564-11\*

Wearshoe

SL 12107106

Location	Loc Qty	Loc Code
FG	4	
77056	4	
FP001	4	
80341	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D209-669-043\*****Parent Item:** D209-669-043**Parent Item Name:** Replacement Skidtube**Start Date:** 29/05/2012**Required Date:** 16/07/2012**Start Qty:** 1.00**Required Qty:** 1.00

D3564-5

Manufactured No

230

Each

13.0000

1

1

\*\*

41 12102106**\*D3564-5\***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
34806	2	
FP001	11	
77609	3	
<u>82254</u>	8	X1

D3566-1

Manufactured No

230

Each

31.0000

2

2

\*\*

41 12102106**\*D3566-1\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	-22	
81619	10	1384874
FP002	53	
68924	2	
80919	3	
<u>83898</u>	16	X1

D3566-5

Manufactured No

230

Each

21.0000

1

1

\*\*

41 12102106**\*D3566-5\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	12	
<u>82275</u>	12	Y1
FP002	9	
80374	3	
82274	6	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

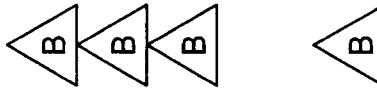
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WITHOUT NOTICE  
WORK ORDER

NO. 84926 MCJ

12/05/29

QTY	QTY	Part Number	Description
-041	-043		
X	X	D2906-041	SKIDTUBE ASSEMBLY
		D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-11-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1	1	D2926-1	WEB
1	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1	1	D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-15	GASKET
50	44	ALS7-1032-130	INSERT
		or AKS7-1032-130	
		or AKS4-1032-130	
		or ALS4-1032-130	
	50	44	AN3C4A
	4	4	AN3-5A
	50	44	AN960C10L
	4	4	AN960UD10L



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

RELEASED

07.04.04

REV.	DESCRIPTION	BY	DATE
B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP PIN; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
DESIGN		DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED		DRAWING NO.	SHEET 1 OF 3
MFG. APPR.	D2906	TITLE	SCALE
APPROVED		AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DE APPR.			
DATE	07.08.21		

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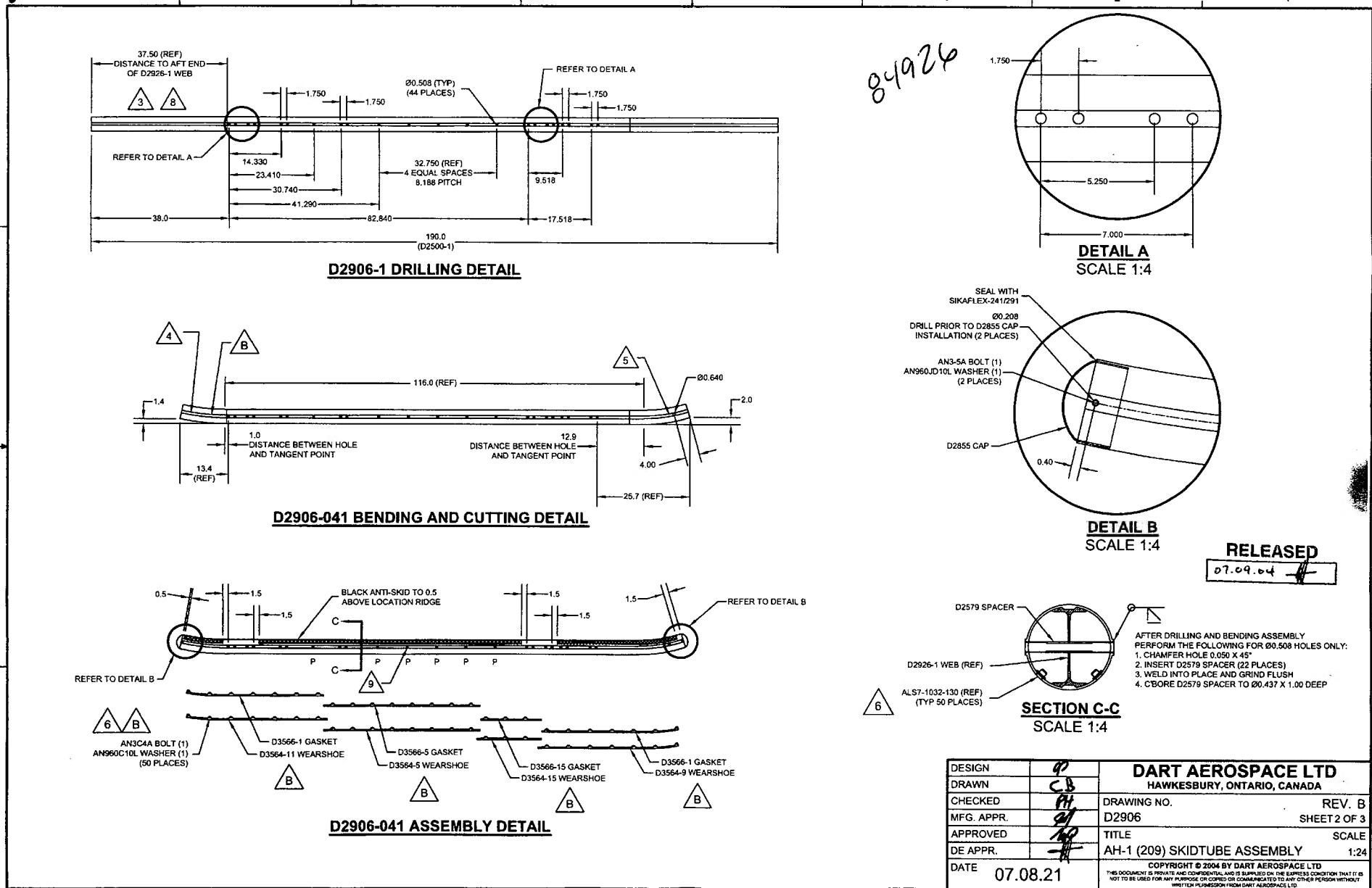
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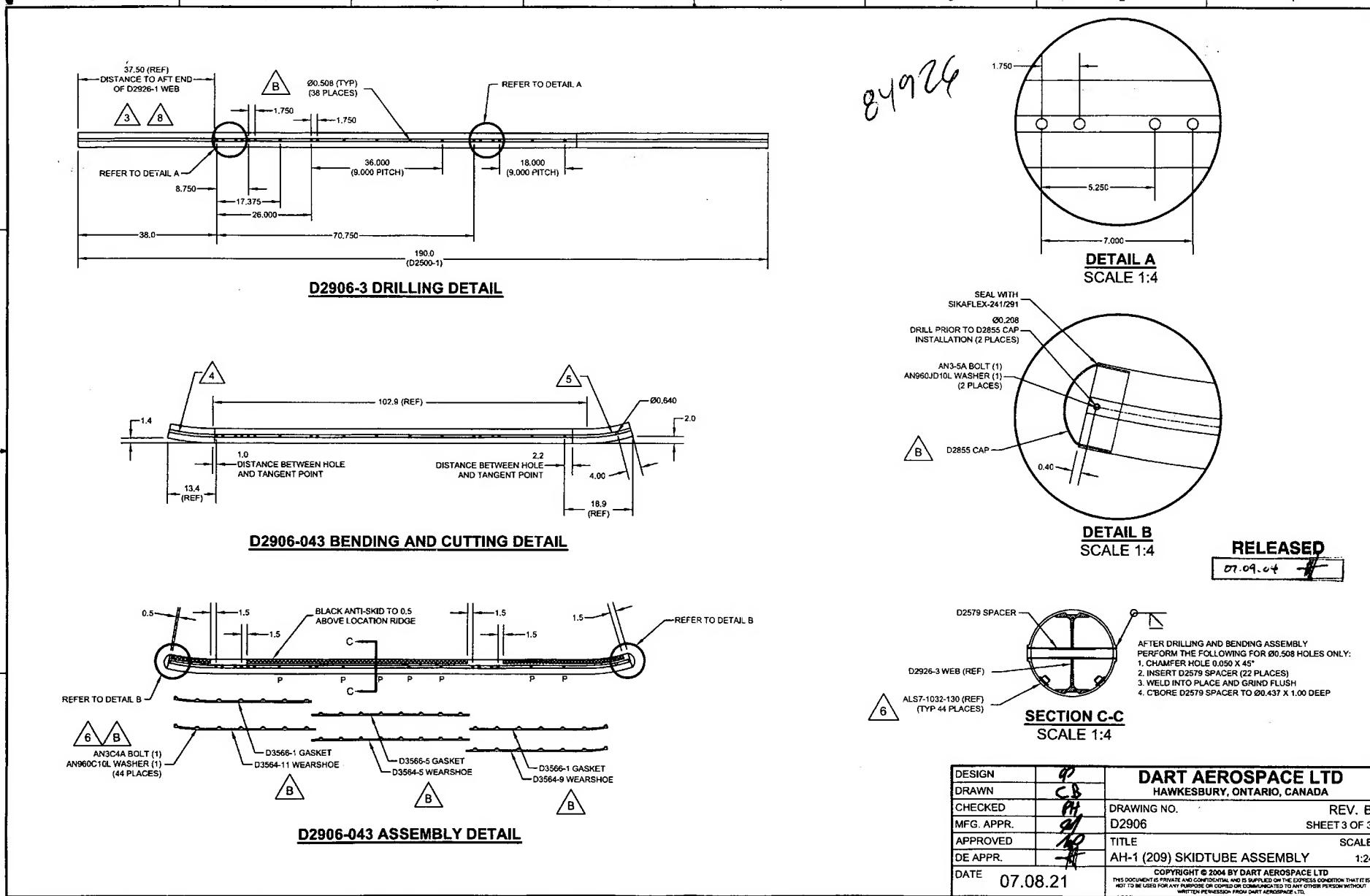
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